

Date: Friday, 23/01/2009 8:46:29 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BLOWER MOTOR ADAPTER
<b>Job Number</b> : 45185	
<b>Estimate Number</b> : 12177	
<b>P.O. Number</b> :	<b>Part Number</b> : D3476041
<b>This Issue</b> : 23/01/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3476 REV A
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SMALL /MED FAB	<b>Drawing Revision</b> : A
<b>Previous Run</b> : 34439	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/02/2009 <b>Qty:</b> <del>3</del> 6 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JUL 09.01.23</u>	
<b>Comment</b> : Est Rev: A New Issue 06-02-03 JLM	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D3476043	Blower Motor Adapter Weldment
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3476-043	ADAPTER WELDMENT	<u>45283</u>

FF 09-06-01

(6)

2.0	D34765	Spacer Ring
-----	--------	-------------



**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3476-5	Ring	<u>B34085</u>

FF 09-06-01

(6)

3.0	AN34A	Bolt
-----	-------	------



**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-4A	Bolt	<u>M103915</u>

FF 09-06-01

(6)

4.0	AN96010	Washer
-----	---------	--------



**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960-10	Washer	<u>M 5519</u>

FF 09-06-01

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 23/01/2009 8:46:29 AM  
User: Julie Dawson

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ADAPTER

Job Number: 45185

Part Number: D3476041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3476

FF 09-06-01

(6)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 09/06/01

(6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a permanent fine point marker and Stock  
Location: 57/56

09/06/02

(6)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/06/02

Job Completion



MF 09-06-02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

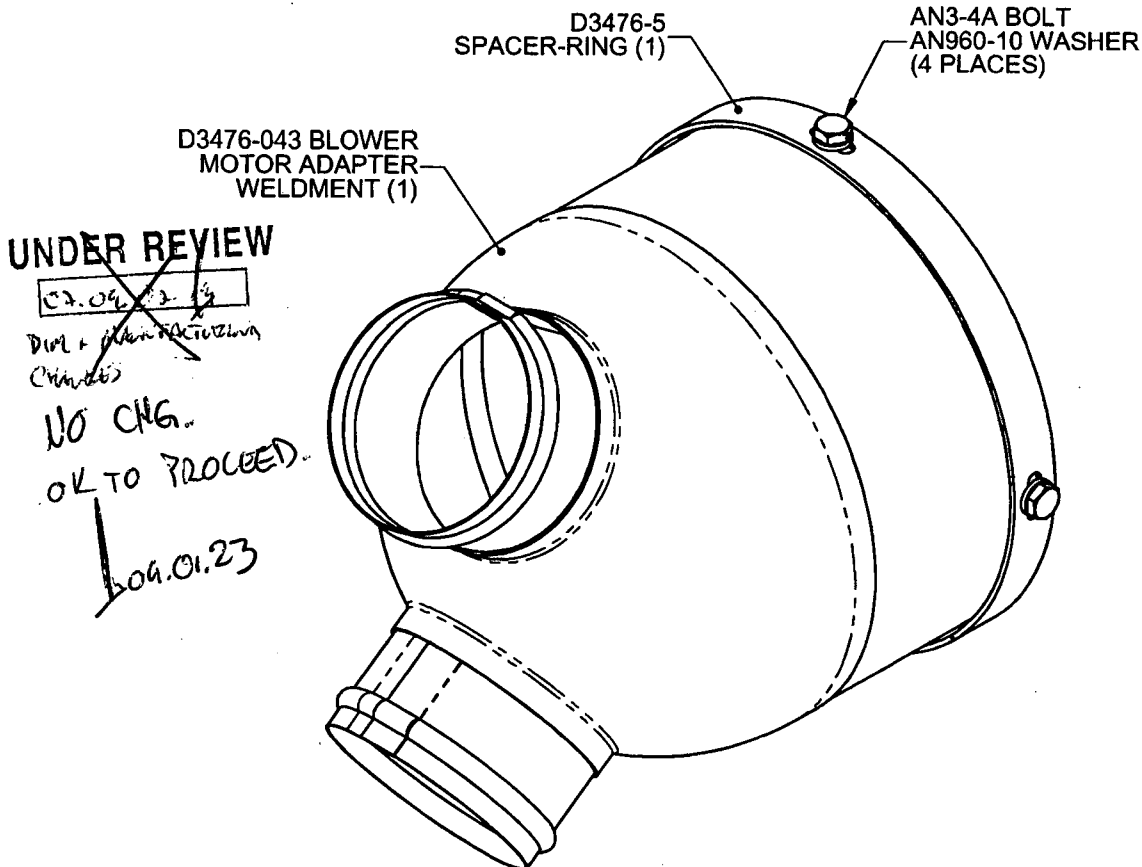
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3476</b>	REV. A SHEET 1 OF 7
DATE <b>06.01.27</b>		TITLE <b>BLOWER MOTOR ADAPTER</b>	SCALE 1:2
A	06.01.27	NEW ISSUE	

*[Signature]* 06.04.03



### D3476-041 BLOWER MOTOR ADAPTER

- 1) IDENTIFY WITH DART P/N D3476-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3476-041	BLOWER MOTOR ADAPTER
1	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-5	SPACER-RING
4	AN3-4A	BOLT
4	AN960-10	WASHER

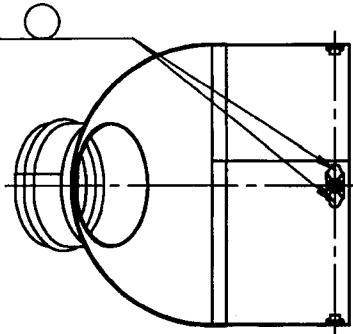
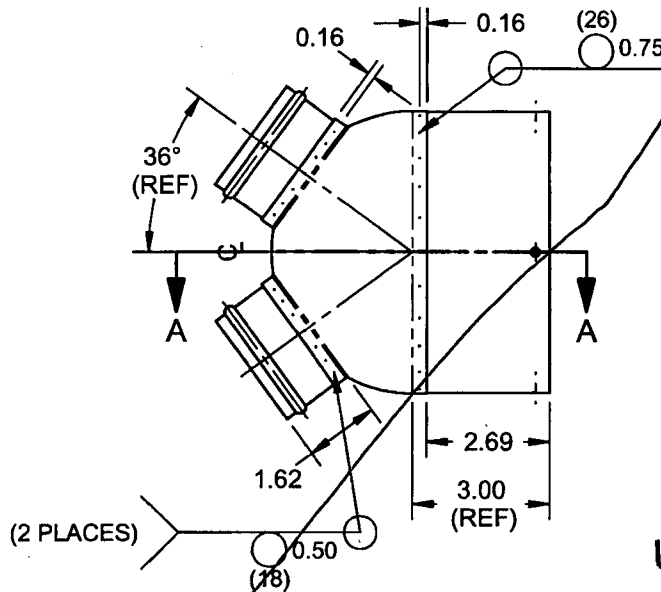
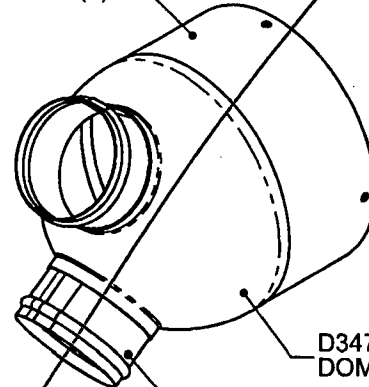
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CHECKED <i>H</i>	APPROVED <i>H</i>	DRAWING NO. <b>D3476</b>	REV. A SHEET 2 OF 7
DATE <b>06.01.27</b>		TITLE <b>BLOWER MOTOR ADAPTER</b>	SCALE 1:4

LOCATE AND  
SPOT WELD  
NUT PLATES  
(4 PLACES)**SECTION A-A**D3476-1  
DUCT (1)D3476-3  
DOME (1)D3476-7 TUBE  
(2 PLACES)NAS-1031C3W  
NUT PLATES  
(4 PLACES)OFFSET SEAM  
ON DUCTSHOP COPY  
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WITHOUT NOTICE**UNDER REVIEW**

02.04.02

DIA. + MANUFACTURING  
(CHIEF)# 06-04-03 WORK ORDER  
NO. 25185**D3476-043 BLOWER MOTOR  
ADAPTER WELDMENT****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) PART IS SYMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -043	P/N	DESCRIPTION
X	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-1	DUCT
1	D3476-3	DOME
2	D3476-7	TUBE
4	NAS1031C3W	NUTPLATE

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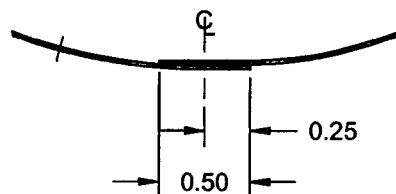
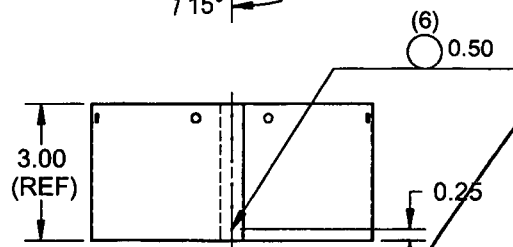
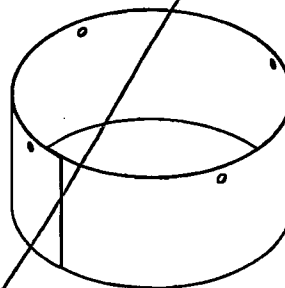
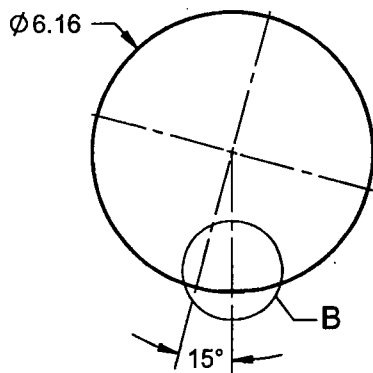
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:4

# 06.07.03

UNDER REVIEW

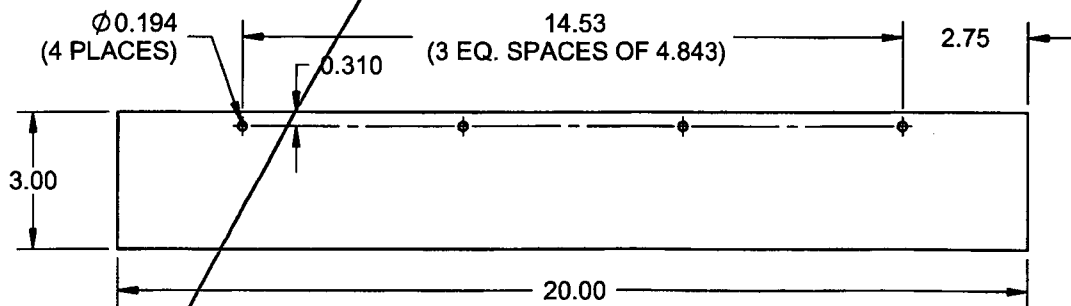
02.09.03

Dim + Manufacturing  
Changes



DETAIL B  
SCALE 1 : 1

**D3476-1 DUCT**



**D3476-1F DUCT FLAT PATTERN**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE <b>06.01.27</b>		TITLE <b>BLOWER MOTOR ADAPTER</b>	SCALE 1:2

RELEASED

06.04.03 *#*

UNDER REVIEW

07.04.03 *#*Dial + planifactor  
(Chris)Ø6.19  
(REF)

C

C

3.41

0.31

R3.06

Ø6.12

0.036  
(REF)**SECTION C-C****D3476-3S DOME, SPINNING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.036 THICK PER MIL-S-5019 (ANNEALED)  
2B FINISH (REF. DART SPEC. M304S20GA)
- 2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING OF MATERIAL (MINIMUM THICKNESS = 0.025").
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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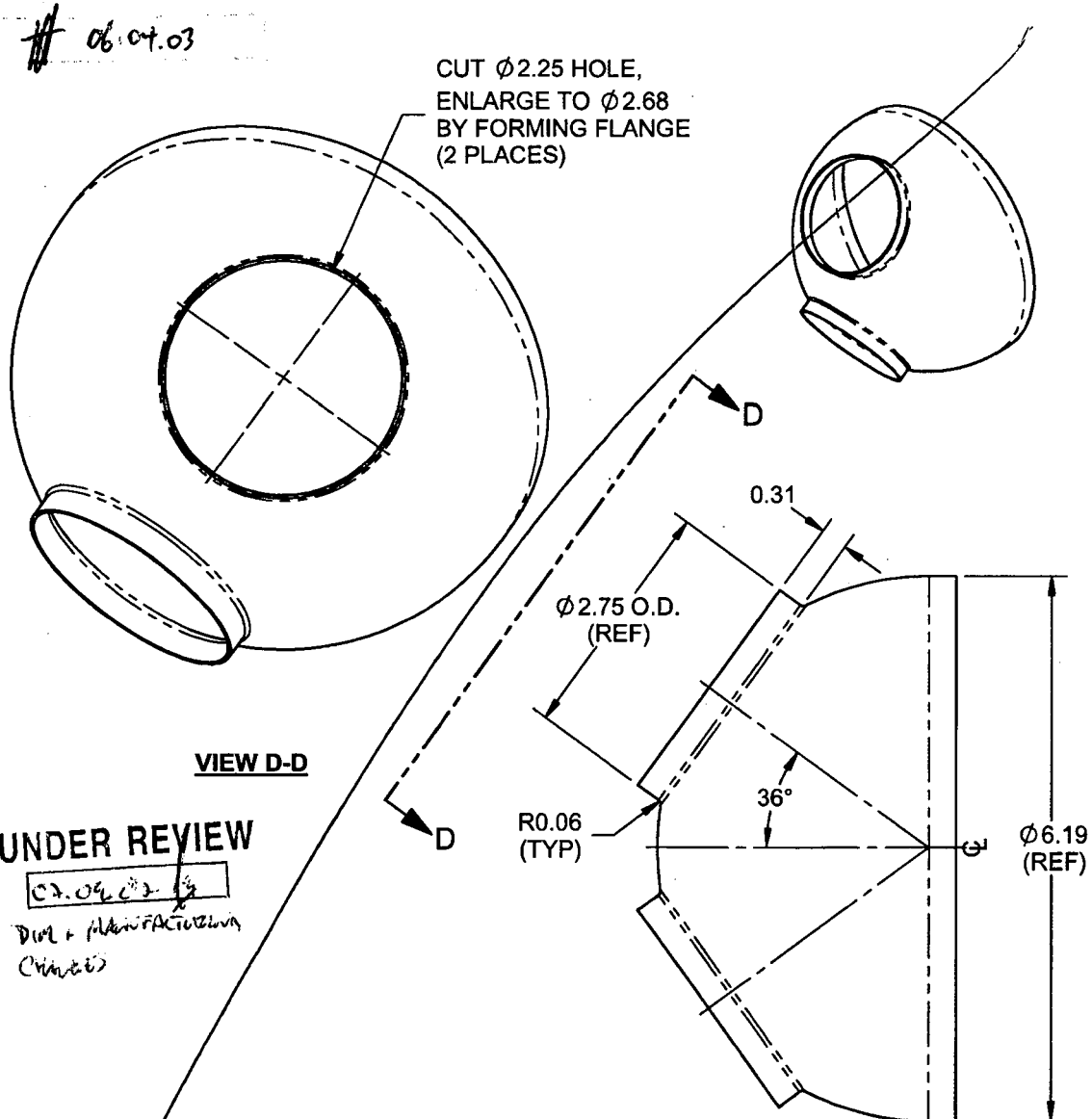
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CHECKED #	APPROVED #	DRAWING NO. D3476	REV. A SHEET 5 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

**D3476-3 DOME****NOTES:**

- 1) MATERIAL: MAKE FROM D3476-3S
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

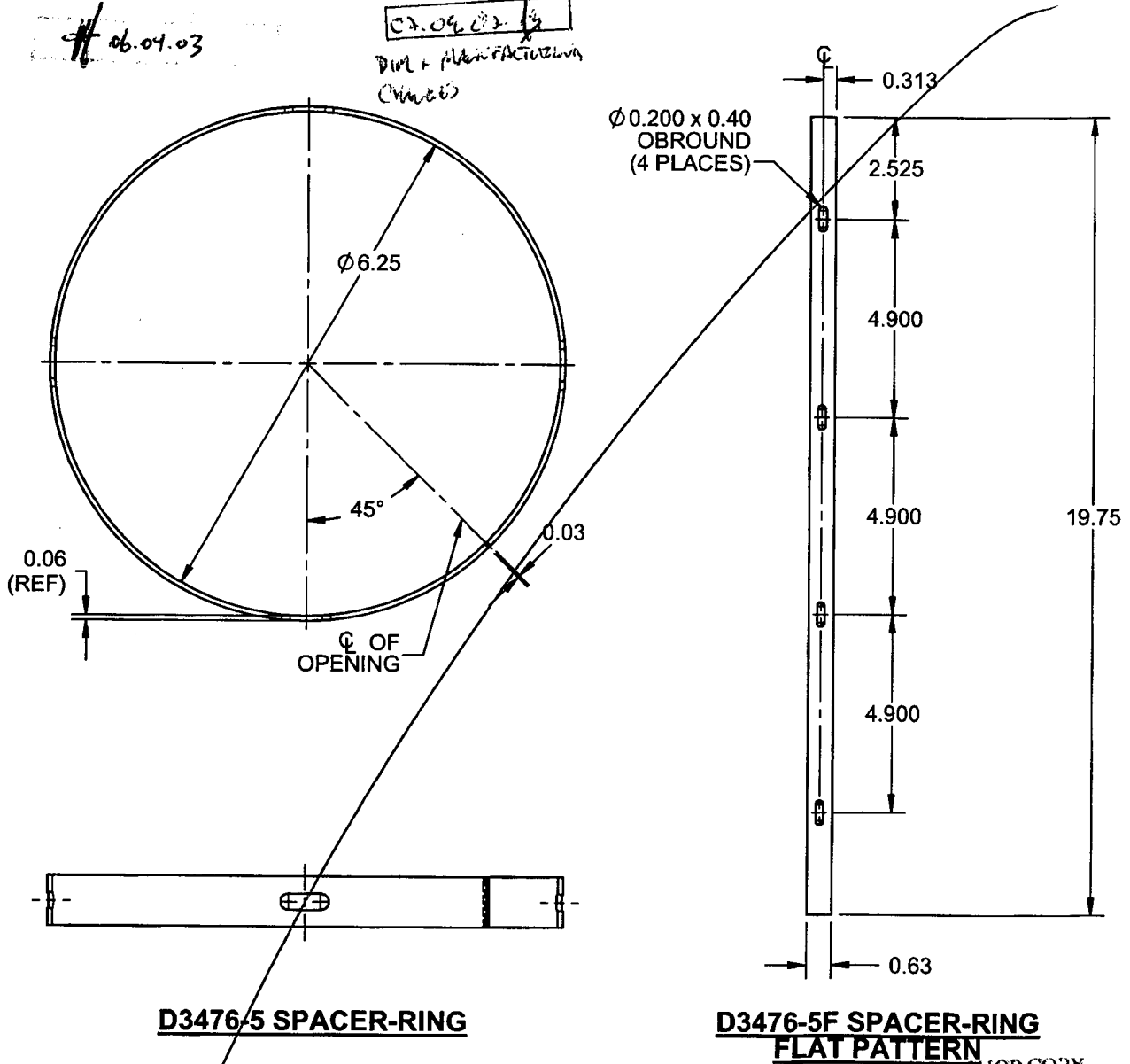
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DATE <b>06.01.27</b>		TITLE <b>BLOWER MOTOR ADAPTER</b>	SCALE 1:2

**UNDER REVIEW****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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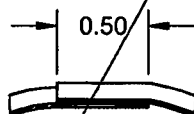
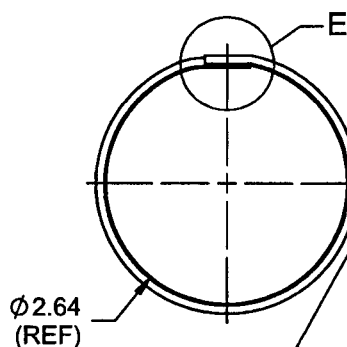
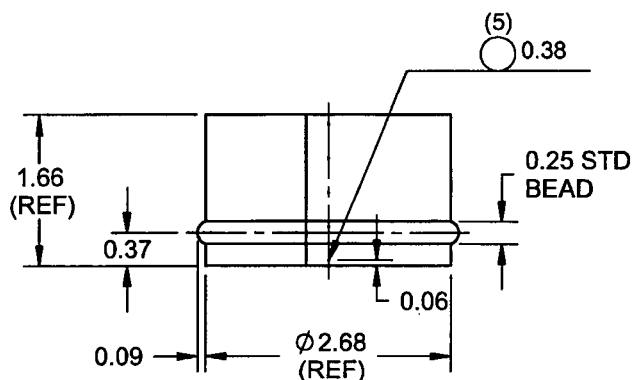
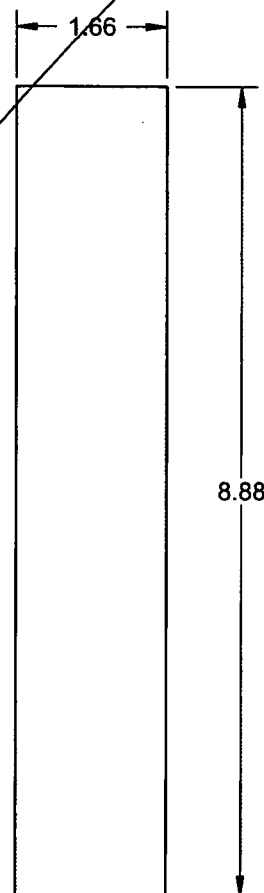
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DATE <b>06.01.27</b>		TITLE <b>BLOWER MOTOR ADAPTER</b>	SCALE 1:2

**UNDER REVIEW***#* 06.04.03

02.04.03

DIAL + MANUFACTURING  
(CHINESE)**DETAIL E**  
SCALE 1:1**D3476-7 TUBE****D3476-7 TUBE**  
**FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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VATUO P...  
WORK...  
4.5185

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